

Date: Thursday, 6/4/2006 11:10:09 AM  
User: Kim Johnston

## Process Sheet

split sp 06/06/24

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY  
Job Number : 26933  
Estimate Number : 10397  
P.O. Number : N/A Part Number : D3155042  
This Issue : 5/4/2006 S.O. No. : N/A Drawing Number : D3155 REV C  
Prsht Rev. : NC Project Number : N/A  
First Issue : N/A Type : R & D SM/MED FAB Drawing Revision : C  
Previous Run : 25283 Material : N/A  
Written By : SEE COMMENT BELOW Due Date : 5/30/2006 Qty: 10 Um: Each  
Checked & Approved By : J.A. 06.05.05  
Comment : Est B 03.02.03 Reformat KJ/RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1000X02000 6061-T6 Bar 1.0" x 2.0"



Comment: Qty.: 0.6125 f(s)/Unit Total: 2.4499 f(s)

Material: 6061-T6/-T651 (QQ-A-200/8 or QQ-A-225/8)

(M6061T6B2.000x01.000)

Batch: M101000

SD 06.05.20

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks: (2.000" x 1.000") x 6.87" Long Bar

SD 06.05.20

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA315 and Dwg D3155

2-Deburr and Tumble

J.L 06/05/24

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 06/05/24

5.0 QC8 SECOND CHECK







Comment: SECOND CHECK

MS 06/05/24

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/06/27							

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/06/28  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/05/24	3	- 1 part dimension .130 is .110 on one side "machined tapered" - is part acceptable?		Part acceptable See Email	J-L 06/05/24			

NOTE: Date & initial all entries



Date: Thursday, 5/4/2006 11:10:09 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 26933

Part Number: D3155042

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*u.m 06-06-08-*

*(10)*

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*SB 06/06/27 10*

8.0 D31553 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bracket Assembly

Qty	Part number	Description	Batch
2	D3155-3	Bushing	<i>B27187 (14)</i>

*SB 06/06/27 (7)*

9.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press fit bushing as per Dwg D3155

*SB 06/06/27 (7)*

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*06-06-27 (7)*

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST410*

*06/06/27 (7)*

12.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*(7) 06/06/27*

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

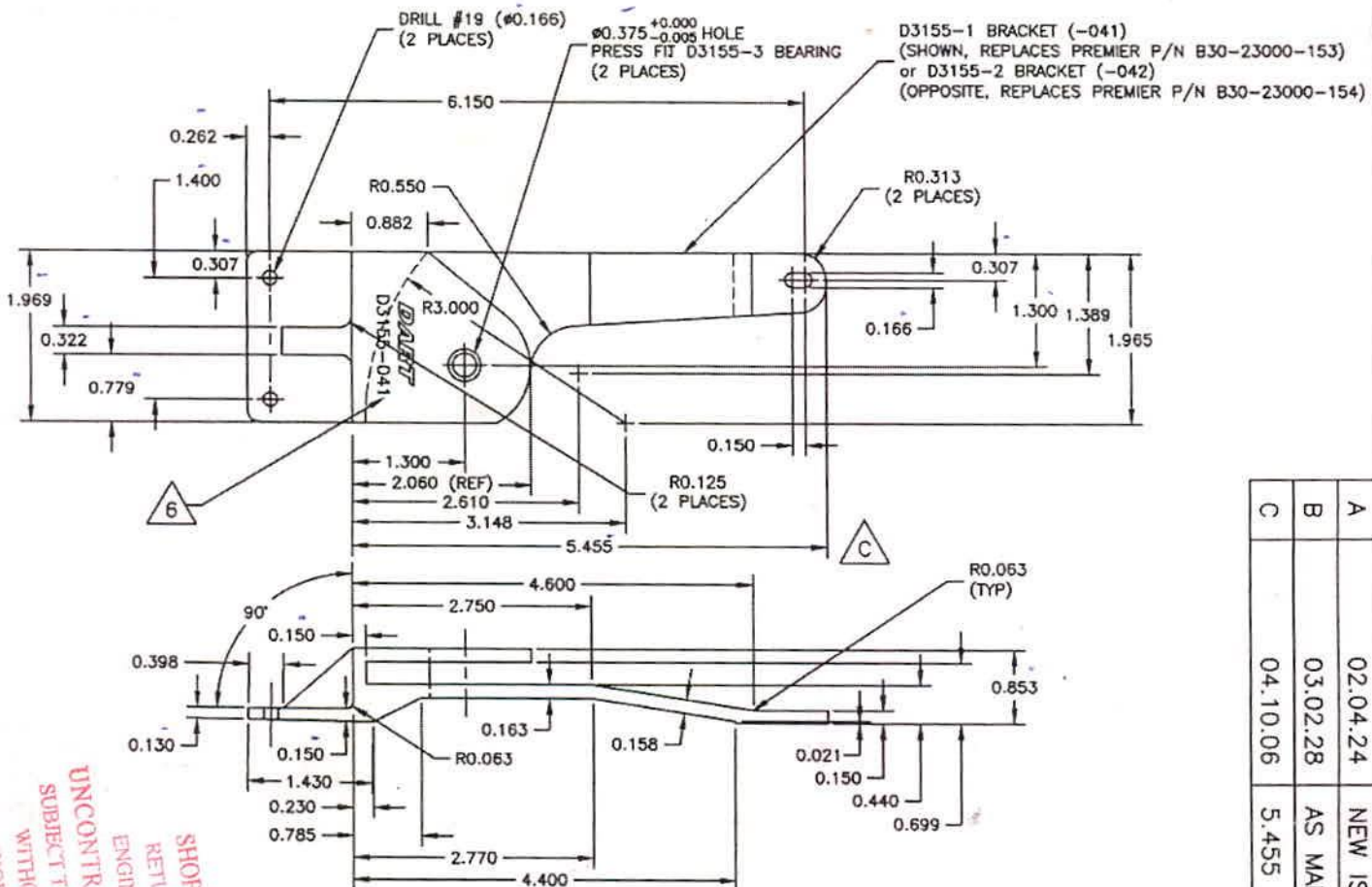
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C	
DATE		D3155	SHEET 1 OF 2	
04.10.06		TITLE	SCALE	
		BRACKET ASSEMBLY	1:2	
A	02.04.24	NEW ISSUE		
B	03.02.28	AS MANUFACTURED		
C	04.10.06	5.455 WAS 5.550		



D3155-041 BRACKET ASSEMBLY

(SHOWN, REPLACES PREMIER P/N B30-23000-11)

D3155-042 BRACKET ASSEMBLY

(OPPOSITE, REPLACES PREMIER P/N B30-23000-12)

D3155-1/-2 BRACKET

- 1) MATERIAL: 6061-T6/-T651 (QQ-A-200/8 OR QQ-A-225/8) BAR  
(REF DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO AS SHOWN

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26933

RELEASED  
09.11.23

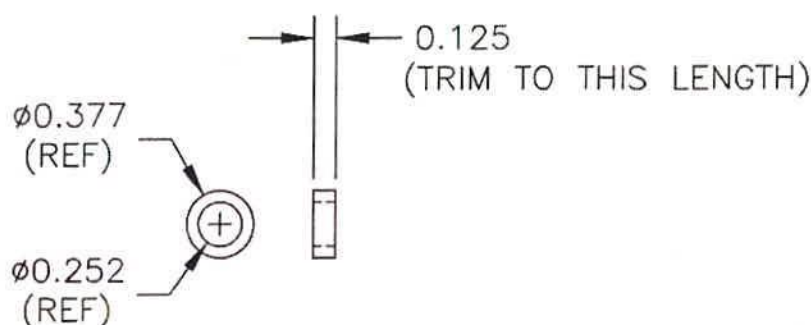
Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3155	REV. C SHEET 2 OF 2
DATE 04.10.06		TITLE BRACKET ASSEMBLY	SCALE 1:1

RELEASED  
04.11.23 [Signature]



### D3155-3 BUSHING

- 1) MAKE FROM P/N SBS-3-3 (SOLID BAR) OR SS-812-20 (TUBING)  
POSSIBLE SUPPLIER: SYMMCO
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26933

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DART AEROSPACE LTD		Work Order: 26933
Description: bracket assembly		Part Number: D3155042
Inspection Dwg: D3155	Rev: C	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
φ.166	+0.005 -0	.169	✓			
φ.375	+0 -0.005	.375	✓			
6.150	+ -0.10	6.148	✓			
.262	"	.262	✓			
1.400	"	1.400	✓			
.307	"	.307	✓			
1.969	"	1.970	✓			
.322	"	.322	✓			
.779	"	.780	✓			
.166	"	.168	✓			
.307	"	.309	✓			
1.300	"	1.298	✓			
.130	"	.130	✓			
.150	"	.148	✓			
.150	"	.153	✓			
.853	"	.848	✓			
.158	"	.162	✓			
.163	"	.169	✓			
1.063	"	.063	✓			
5.455	"	5.458	✓			
4.600	"	4.594	✓			
2.060	"	2.060	✓			
.021	"	.023	✓			

Measured by: J.L.	Audited by: JMK	Prototype Approval: N/A
Date: 06/05/23	Date: 06/05/23	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

**Linda Lacelle**

---

**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** Monday, June 05, 2006 12:07 PM  
**To:** 'Jason Murdoch'  
**Cc:** 'Linda Lacelle'  
**Subject:** RE: d3155

Jason,

These parts are acceptable deviations.

David

---

**From:** Jason Murdoch [mailto:jmurdoch@dartaero.com]  
**Sent:** Monday, June 05, 2006 9:51 AM  
**To:** davids@dartaero.com  
**Subject:** FW: d3155

Any chance I can get an answer on these?

[jmurdoch@dartaero.com](mailto:jmurdoch@dartaero.com)

**Q.C.Inspector**

---

**From:** Jason Murdoch [mailto:jmurdoch@dartaero.com]  
**Sent:** May 31, 2006 9:45 AM  
**To:** davids@dartaero.com  
**Subject:** d3155

Good day. I have some parts off the haas that are under tol. If you look at dwg 3155-041/-042 the thickness of mat'l should be .130, and the taper I have comes down to .110 at the very tip of the mat'l. These holes are only for bolting on to the space doors to keep the lock and rod mechanism up higher. 1<sup>st</sup> : .110 ; 2<sup>nd</sup> : .110 ; 3<sup>rd</sup> : .114. Are these parts acceptable to you?

[jmurdoch@dartaero.com](mailto:jmurdoch@dartaero.com)

**Q.C.Inspector**